

Date: Monday, 2/11/2008 11:38:34 AM
 User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: R44 BEARPAW INSTALLATION
 Job Number: 37315
 Estimate Number: 12682
 P.O. Number:
 This Issue: 2/11/2008 S.O. No.:
 Prsht Rev.: NC Part Number: D044662013
 First Issue: 1/1 Type: MACHINED PARTS Drawing Number: IIN D044-662 REV D
 Previous Run: 31589 Drawing Revision: D
 Material:
 Due Date: 2/28/2008 Qty: 3 Um: Each
 Written By:
 Checked & Approved By: KS 08 02 11
 Comment: Est Rev:A New Issue 07-01-30 JLM
 Est Rev:B As per IIN 044-662 REV D 07-03-28 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD044-662-013 CHG 001

KS 08.02.12 (3)

2.0	37315A	R44 BEARPAW
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Comment: Sub-Component R44 BEARPAW D3529-1 SUB-COMPONENT

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 1.5750 f(s)/Unit Total: 9.4500 f(s)

Neoprene Cushion-.750 bl

4 X 4.5" PCS

Batch: 135769

SP

5.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Washer

Batch: B37210

AS 08/03/04

(X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: R44 BEARPAW INSTALLATION

Job Number: 37315

Part Number: D044662013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35561

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Clamp

Batch:

B37198

AS 08/03/04

(X3)

7.0

D36011

RADIUS BLOCK



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

RADIUS BLOCK

Batch:

B31634 (X)

B37653 (X)

SP

8.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

BATCH:

M105653

AS 08/03/04

(X3)

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

BATCH:

M106375

AS 08/03/04

(X3)

10.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Batch:

106277

AS 08/03/04

(X3)

11.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut

Batch:

M105938

AS 08/03/04

(X3)

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0603-11 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/03/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: R44 BEARPAW INSTALLATION

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Part Number: D044662013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-013

Location: A

PPP Rev: A

8/3/11 54 BX

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/12

Job Completion



2008/3/12

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
4	4		D2182B045	Rubber Cushion
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		AN960JD416	Washer
8	8	4	MS21042L4	Nut (or MS21042-4)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37315

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Revision: D

Date: 07.02.14